



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2573

Job Sheet 177093



Part No: D2573

Job Qty: 10 ea

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/4/18

Job Tracking No:

Due Date: 5/18/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV F IPP: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	5/18/18	5/18/18	0.00	0.00	Start Up Machining		SBZ 18/06/06
100	CNC Vertical Machining	10 pcs	5/18/18	5/18/18	1.01	16.67	HAAS 1		SBZ 18/06/05
110	Mill Conv	10 pcs	5/18/18	5/18/18	0.00	1.67	Mill Conv 1		SBZ 18/06/05
130	QC	10 pcs	5/18/18	5/18/18	0.00	0.00	QC8		SA 18/06/11
140	HandFinish	10 pcs	5/18/18	5/18/18	0.00	0.47	HandFinish1		SA 18-06-12
150	Powdercoat	10 pcs	5/18/18	5/18/18	0.00	0.38	Powdercoat1		SA 18-06-13
160	QC	10 pcs	5/18/18	5/18/18	0.00	0.00	QC3		JUN 14 2018
170	Packaging	10 pcs	5/18/18	5/18/18	0.00	0.00	Packaging3		9-89
180	QC21-SA	10 Ea	5/18/18	5/18/18	0.00	0.00	QC21		21 18-06-15 9-89

Part Op 100 - Program Batch No.

Descriptions: 110 - Machine keyway as per dwg D2573 & D2574

150 - START TIME: 10:30

OUT: 3:00 FINISH: 11:00

M 138839

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	10 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	10	20	0

SOG9074 → SO77016

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Outboard	0.438Inches	+ 0.005 - 0.000	0.443 0.438	
2	Saddle, Aft Outboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	
3	Saddle, Aft Outboard	3.495Inches	+ 0.010 - 0.000	3.505 3.495	
4	Saddle, Aft Outboard	1.745Inches	+ 0.010 - 0.000	1.755 1.745	

Plex 5/4/18 3:04 PM Dart.Gagnon.Michelle



Dart Aerospace Ltd.
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CANADA
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Container No: S077017



Part: D2573

Job No: 177093

Serial No/Batch: S077017

Revision:

Inspector:

Exp Date: 06/01/2018

Instructions:

Date: 06/01/18

5	Saddle, Aft Outboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Aft Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Aft Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Aft Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Outboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Outboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Outboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Aft Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Outboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Outboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

DART AEROSPACE LTD		Work Order: 177093	
Description: Saddle, Aft Outboard		Part Number: D2573	
Inspection Dwg: D2573 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.0025	8.002	8.0005		
F	0.490	0.510		0.507	0.501	0.503	0.503		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.375	0.375	0.375		
I	0.490	0.510		0.500	0.502	0.503	0.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.571	0.5695	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.130	0.135	0.135	0.135		
Q	0.115	0.135		0.125	0.126	0.1265	0.126		
R	0.240	0.260		0.250	0.252	0.252	0.253		
S	0.115	0.135		0.125	0.130	0.130	0.130		
T	0.178	0.198		0.185	0.188	0.188	0.188		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		0.240	0.240	0.240	0.233		
W	0.115	0.135		0.127	0.129	0.133	0.132		
X	0.308	0.313		0.310	0.310	0.314	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.364	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.619	0.629	0.627	0.627		
AC	0.053	0.073		0.055	0.065	0.065	0.065		
AD	0.240	0.260		0.252	0.253	0.253	0.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.122	0.125	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.250	0.250	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: SBL
Date: 18/06/05

Audited by: [Signature]
Date: 18/06/11

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 177 093
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	87	48	By	Date
A	0.438	0.443		0.438	0.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.0005	8.001	8.004		
F	0.490	0.510		.500	.502	.502	.500		
G	0.257	0.262		0.257	0.257	.257	.257		
H	0.375	0.380		0.375	0.375	.375	.375		
I	0.490	0.510		.502	0.5045	.502	.5001		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	0.570	.570	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.133	0.135	.130	.130		
Q	0.115	0.135		.127	0.127	.127	.127		
R	0.240	0.260		.255	0.255	.255	.254		
S	0.115	0.135		.120	0.130	.127	.122		
T	0.178	0.198		0.188	0.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.237	0.235	.237	.237		
W	0.115	0.135		.123	.130	.124	.126		
X	0.308	0.313		.312	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.365	.365	.365		
AA	0.470	0.530		0.500	0.500	.500	.500		
AB	0.615	0.635		.627	.623	.627	.628		
AC	0.053	0.073		0.065	0.065	.062	.065		
AD	0.240	0.260		.250	.251	.251	.251		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.120	.125	.120	.118		
AG	0.240	0.280		0.265	0.265	.265	.260		
AH	0.240	0.260		0.250	0.250	.249	.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: SBC	Audited by: [Signature]
Date: 18/06/05	Date: 18/06/11

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				9 ¹	10 ²	3	4		
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B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
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E	7.990	8.010		8.002	8.002				
F	0.490	0.510		.503	.502				
G	0.257	0.262		.257	.257				
H	0.375	0.380		.375	.375				
I	0.490	0.510		.500	.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.570	.569				
L	1.174	1.184		1.179	1.179				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.124	4.124				
P	0.115	0.135		.133	.130				
Q	0.115	0.135		.126	.127				
R	0.240	0.260		.255	.254				
S	0.115	0.135		.126	.126				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		.238	.237				
W	0.115	0.135		.126	.125				
X	0.308	0.313		.310	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.365	.365				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.628	.627				
AC	0.053	0.073		.060	.060				
AD	0.240	0.260		.249	.250				
AE	1.500	1.520		1.510	1.510				
AF	0.115	0.135		.125	.115				
AG	0.240	0.280		.265	.265				
AH	0.240	0.260		.251	.250				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by: SB L
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